

# Work Order ID 86296

June-26-12 3:38:42 PM

**\*86296\***

Page 1

Item ID: D2330-041  
Revision ID:  
Item Name: Basket Base Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 26/06/2012 Start Qty: 1.00  
Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***  
**\*1\***

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2330	Rev H

100 0.00

**\*100\***

Large Fab

Memo

0.00

Large Fab

1 - weld as per dwg D2330 and QSI 004

S.S Rod batch: M122130

PD 12-10-15

110 0.00

**\*110\***

QC

Memo

0.00

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds



12-10-15

1x

120 0.00

**\*120\***

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O



12-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*86296\***

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Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Start Date: 26/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	Pressure Wash per QSI005 4.3	0.00							
<b>*125*</b>									
HandFinish	Memo	0.00				1	76	12-10-16	
Hand Finishing									
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
<b>*130*</b>									
Powdercoat									
Powder Coating									
	Memo	0.00							
	Start Time: 10:00								
	Oven Temperature: 4000F								
	Finish Time: 10:30								
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC									
Quality Control	Memo	0.00							

W122878

IX ✓ MF 12/10/16

DAS 16 11/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*86296\***

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Item ID: D2330-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Basket Base Assembly

Stop **\*NS2\***

Start Date: 26/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: *D200-040-013*

**\*150\***

Packaging

Memo

0.00

*1*

*0*

*RL 12-10-16*

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

*12/10/18*

Quality Control

*12-10-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 86296

\*86296\*

Parent Item: D2330-041

\*D2330-041\*

Parent Item Name: Basket Base Assembly

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:H02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ

IPP Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verF by:EC

IPP REV:J 10.11.30 AS PER DWG REV.H DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-107

Manufactured No

100 Each 26.0000

1 1

\*D2012-107\*

Clevis

\*\*

12-10-03

PD

### Location

### Loc Qty

### Loc Code

ST

6

82039

6

WA005

20

85862

20

D2235-1

Manufactured No

100 Each 22.0000

4

4

\*D2235-1\*

Basket Rib

\*\*

12-10-03

PD

### Location

### Loc Qty

### Loc Code

WA

18

78636

5

81910

1

82951

2

85602

4

86051

6

WA005

4

66895

4

D2252-1

Manufactured No

100 Each 0.0000

2

2

\*D2252-1\*

Frame

\*\*

891047 -> (2) 12-10-03 PD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 86296

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

\*86296\*

\*D2330-041\*

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D2252-7  
\*D2252-7\*  
Frame

Manufactured No

100

Each

3.0000

1

1

\*\*

12-10-03 PD

Location

Loc Qty

Loc Code

WA

1

83978

1

WA006

2

73201

2

~~B91017~~ → 10  
B91395 → 10

Manufactured No

100

Each

11.0000

2

2

\*\*

12-10-03 PD

Location

Loc Qty

Loc Code

WA005

11

53965

11

100

Each

42.0000

2

2

\*\*

12-10-03 PD

Location

Loc Qty

Loc Code

WA005

42

39801

42

100

Each

30.0000

1

1

\*\*

12-10-03 PD

✓ D2327-3  
\*D2327-3\*  
Spacer Bushing

Manufactured No

Location

Loc Qty

Loc Code

WA

26

82325

26

WA005

4

75564

1

77229

1

81144

2

B88561

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 86296

**\*86296\***

Parent Item: D2330-041

**\*D2330-041\***

Parent Item Name: Basket Base Assembly

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D2330-1	Manufactured	No	100	Each	0.0000	2	2																												
<b>*D2330-1*</b>						**		B91049 → ② 12-10-03 PD																											
Frame																																			
✓ D2330-5	Manufactured	No	100	Each	2.0000	1	1																												
<b>*D2330-5*</b>						**		12-10-03 PD																											
Frame																																			
<table> <tr> <th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th><td colspan="6"></td></tr> <tr> <td>WA</td><td>2</td><td></td><td colspan="6">B91050 → ① *</td></tr> <tr> <td>75818</td><td>2</td><td></td><td colspan="6"></td></tr> </table>									<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							WA	2		B91050 → ① *						75818	2							
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																	
WA	2		B91050 → ① *																																
75818	2																																		
⌋ D2330-7	Manufactured	No	100	Each	0.0000	1	1																												
<b>*D2330-7*</b>						**		B86302 → ① 12-10-03 PD																											
Frame																																			
⌋ D2581	Manufactured	No	100	Each	79.0000	4	4																												
<b>*D2581*</b>						**		12-10-03 PD																											
Mounting Bracket																																			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	49	
82506	2	
83230	3	
85436	20	
85452	24	
WA005	30	
70766	2	
81253	1	
82897	27	

B87706 → 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 86296

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

\*86296\*

\*D2330-041\*

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3748-1

Manufactured No

100

Each

14.0000

3

3

\*D3748-1\*

Hinge Half

\*\*

PD 12-10-03

Location

Loc Qty

Loc Code

WA005

14

68884

2

76280

12

M304EX0.75-16F

Purchased

No

100

sf

849.3859

30

30

\*M304FX0 75-16F\*

Expanded Metal Flat SS

\*\*

PD 12-10-03

Location

Loc Qty

Loc Code

WA

4.9094

121738

4.9094

WA035

844.4764637

117197

102.9036

120917

101.57273

121521

0.00013372

122080

320

122138

320

D3833-1

Manufactured

No

100

Each

5.0000

2

2

\*D3833-1\*

Mesh (Base End Face)

\*\*

PD 12-10-03

Location

Loc Qty

Loc Code

WA

4

77521

4

WA035

1

81259

1

(mesh end caps)

B85697 → (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 86296 MCT  
12/06/26

RELEASED  
2010-11-25

**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/9/13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB	DRAWING NO.	REV. H
CHECKED	JB	D2330	SHEET 1 OF 6
MFG. APPR.	JB	TITLE	SCALE
APPROVED	JB	BASKET ASSEMBLY (206B)	NTS
DE APPR.	JB	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.09.28		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

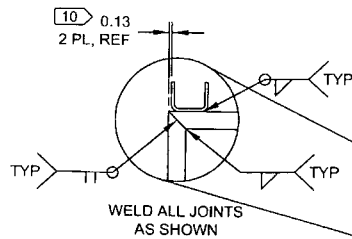
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

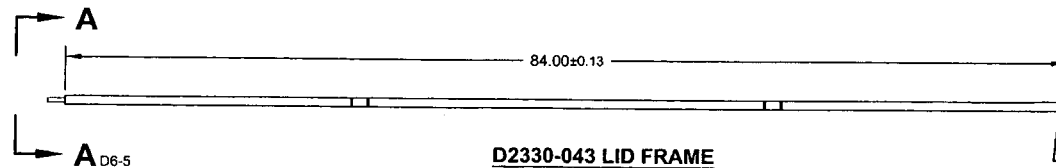
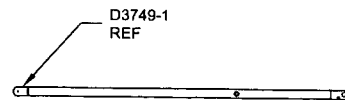
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





SEE DETAIL G  
A2-5



**LID FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

**D2330-043 LID FRAME**

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED  
2010-11-25

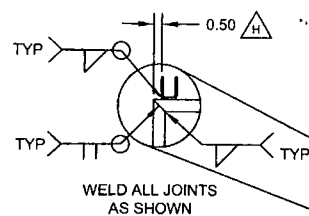
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

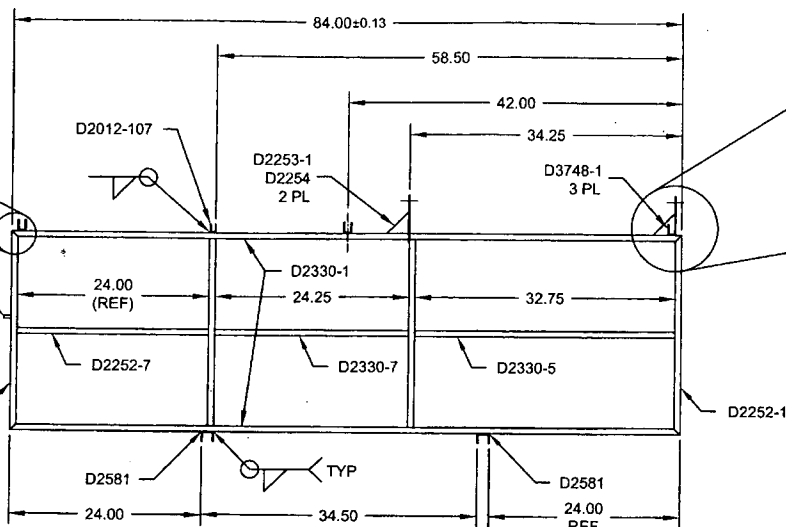
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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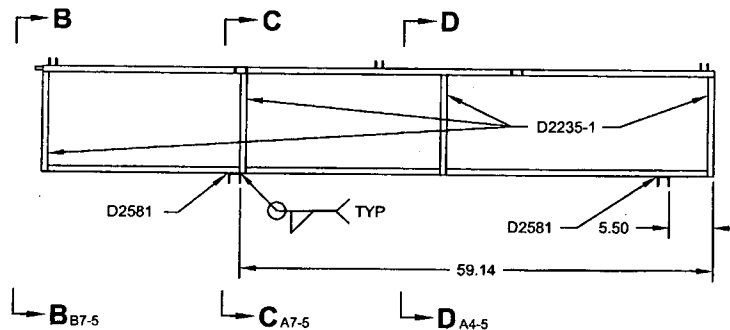
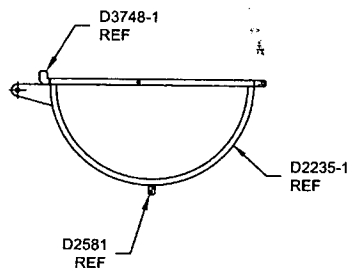
**NOTE:** Date & initial all entries



SEE DETAIL G  
D2327-3  
REF  
A2-5



86296



# **D2330-041 BASE FRAME ASSEMBLY**

## **BASE FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	For JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	up	DRAWING NO.	REV. H
MFG. APPR.	M	D2330	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NT
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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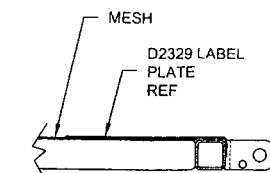
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

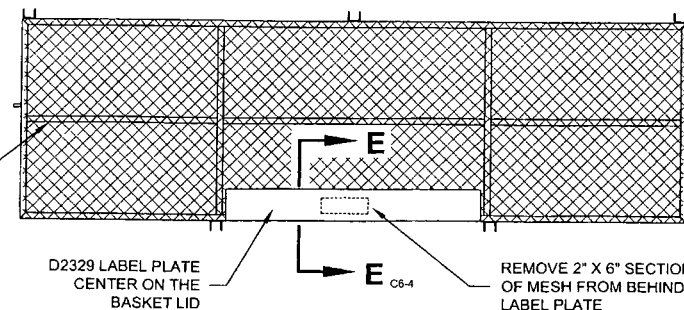
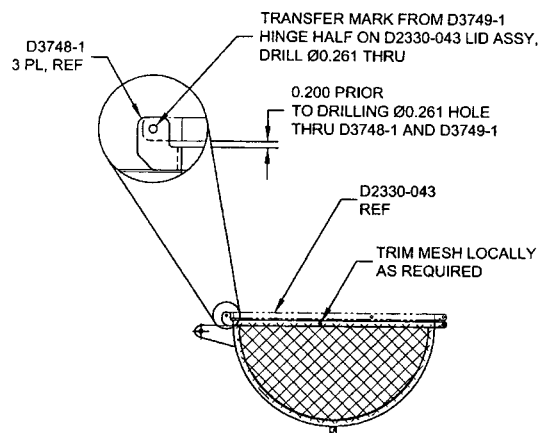
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

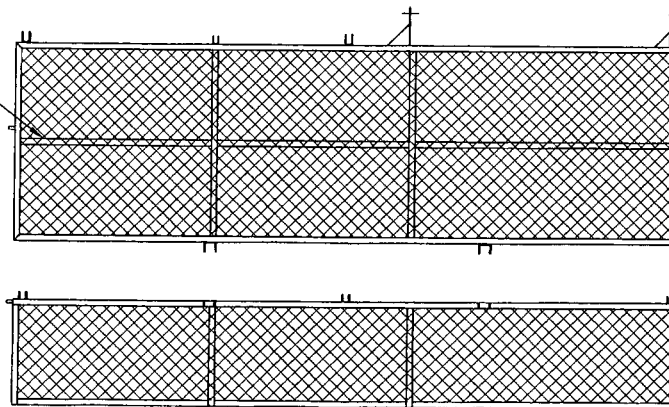


**SECTION E-E** C3-4  
VIEW ROTATED 90° CCW

TACK WELD EACH  
STRAND END OF  
MESH TO FRAME



**D2330-043 LID ASSEMBLY**



**D2330-041 BASE ASSEMBLY**

**ASSEMBLY NOTES:**

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D2330	SHEET 4 OF 6
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

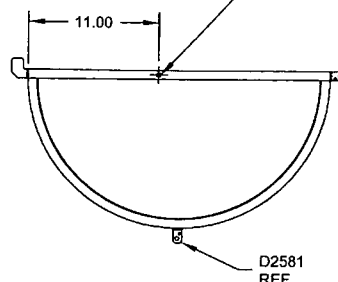
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

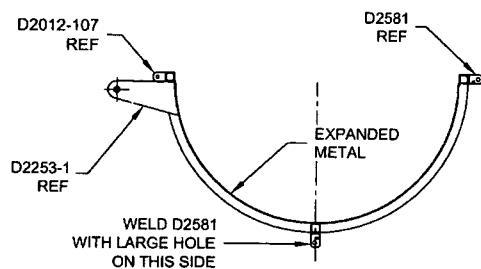


**VIEW A-A** A6-2

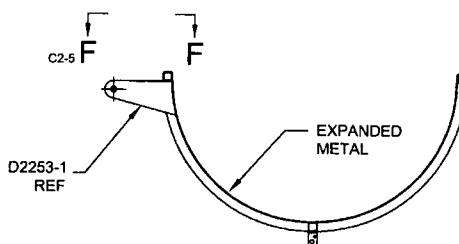
DRILL 3/8 HOLE AND  
INSTALL D2327-3  
SEE DETAIL G A2-5



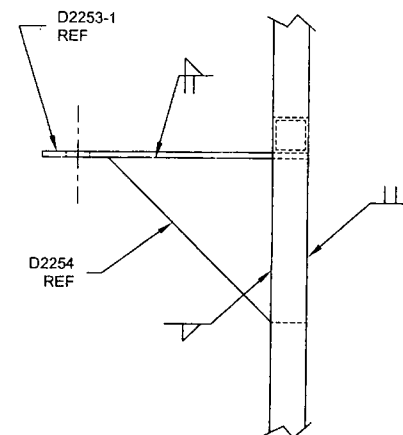
**VIEW B-B** A5-3



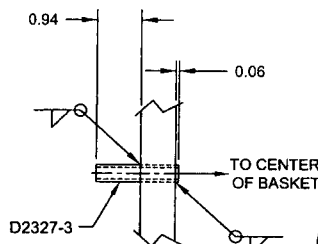
**SECTION C-C** A4-3



**SECTION D-D** A3-3



**VIEW F-F** B6-5  
SCALE 4X



**DETAIL G**  
SPACER INSTALLATION  
SCALE 4X

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MFG. APPR.	JP	D2330	SHEET 5 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

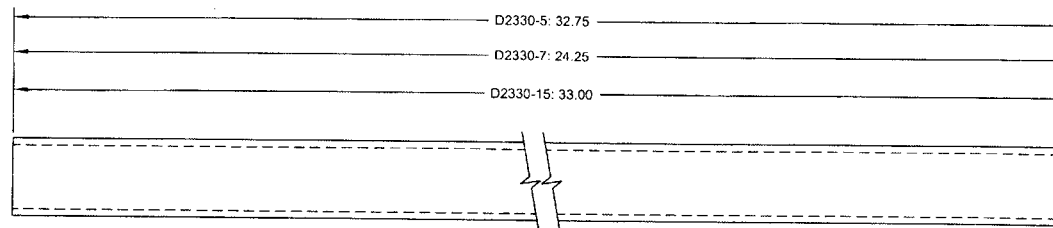
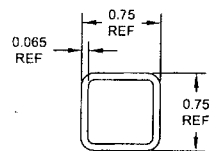
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

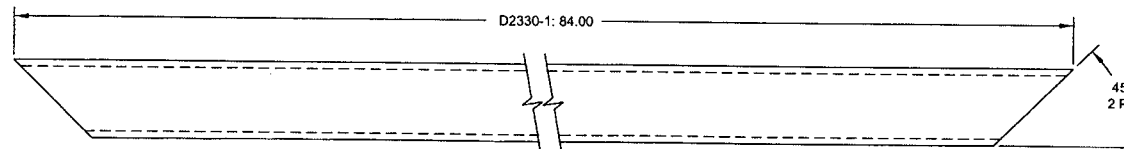
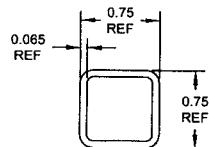


D

D2330-5 FRAMED2330-7 FRAMED2330-15 FRAME

C

B

D2330-1 FRAME

A

**NOTES:**

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
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MFG. APPR.	<i>[Signature]</i>	D2330	SHEET 6 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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